

shp 08/03

Work Order ID 56578



March 1, 2010 2:45:25 PM

Item ID: D3713-042
Revision ID:
Item Name: Lid Assembly

Accept



Setup Start
Stop



Start Date: 3/01/10 Start Qty: 1.00
Required Date: 3/08/10 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3713	Rev B

100 0.00



Large Fab

Large Fab

Memo

Large Fab

1- drill holes in both D3715-1 as per dwg D3715 2- deburr 3- assemble as per dwg D3713 and weld as per QSI004

110 0.00



Large Fab

Large Fab

Memo

Large Fab

1- cut mesh as per dwg D3743 2- weld mesh as per dwg D3713

LP SAD 10-03-02

120 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

Quality Control

S.olorlos

sh 10/03/08 (1+)

sh 10/03/08 (1x)

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Cpl 10-03-08

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:30 AM

OVEN TEMPERATURE:

8:00 AM FINISH TIME:

320°F

⇒ M 10/03/09

(XI) φ

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-3-9

① φ

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

M 113462

0.00

1-Apply Wing Walk on mesh as per Dwg D3713 and QSI 005 4.4 2-apply
armor shield over label on lid only
Label B# 55439
Armor shield B# 105320

BR 1039

ml 10/03/12 0

0.

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

R 10/3/19

180



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

PP 57057

10-3-19 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*1003-19**CL1013119*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56578



Parent Item: D3713-042



Parent Item Name: Lid Assembly

Start Date: 3/01/10

Required Date: 3/08/10

Comments: IPP Rev:A new issue 08-01-30 DD verified by:EC
IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1		Manufactured	No			100	Each	33.0000	2.0000			
Spacer Bushing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	33	
52832	13	
54658	20	

D2329



Label Plate

Manufactured	No											
						110	Each	12.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	12	
35686	2	
40488	10	

2x SY 10/03/01

1x SY 10/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 3/01/10

Required Date: 3/08/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	47.0000	2.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	5	
46086	2	
48428	1	
51120	2	
Main Warehouse		
WA	42	
50872	1	
51745	2	
55918	39	

D3749-1



Hinge Half

Manufactured	No											
						100	Each	12.0000	3.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	12	
38826	12	

2x 10/03/01

3x 10/03/01

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 3/01/10

Required Date: 3/08/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	873.8291	17.8947			
Expanded Metal Flat SS												

SAD 10-03-02

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	873.8291065	
111956	0.000017	
112147	9.4736E-06	
112949	19.84438	
113205	0.0093	
113497	0.1449	
113555	667.7873	
113904	186.0432	

M304TS0.750W.065

Purchased

No

100 f

221.2637 32.6547



304 SQ Tube .75x.75x.065W

17.8947

SAD 10-03-02

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	221.2636712	
113082	0.00419	
113245	0.00038421	
113683	0.30855	
113836	5.161147	
113956	215.7894	
Main Warehouse		
WA	0.0000047	
112398	0.0000047	

4.18128
28.4756

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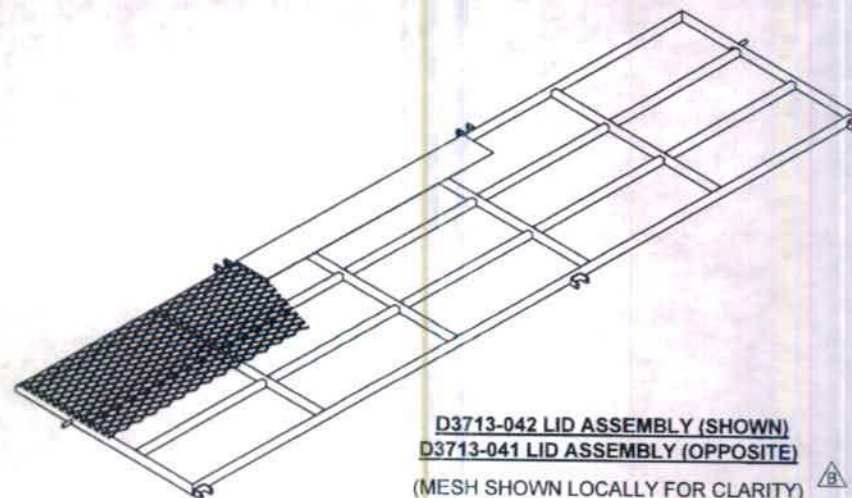
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	MESH
3	3	D3749-1	HINGE HALF

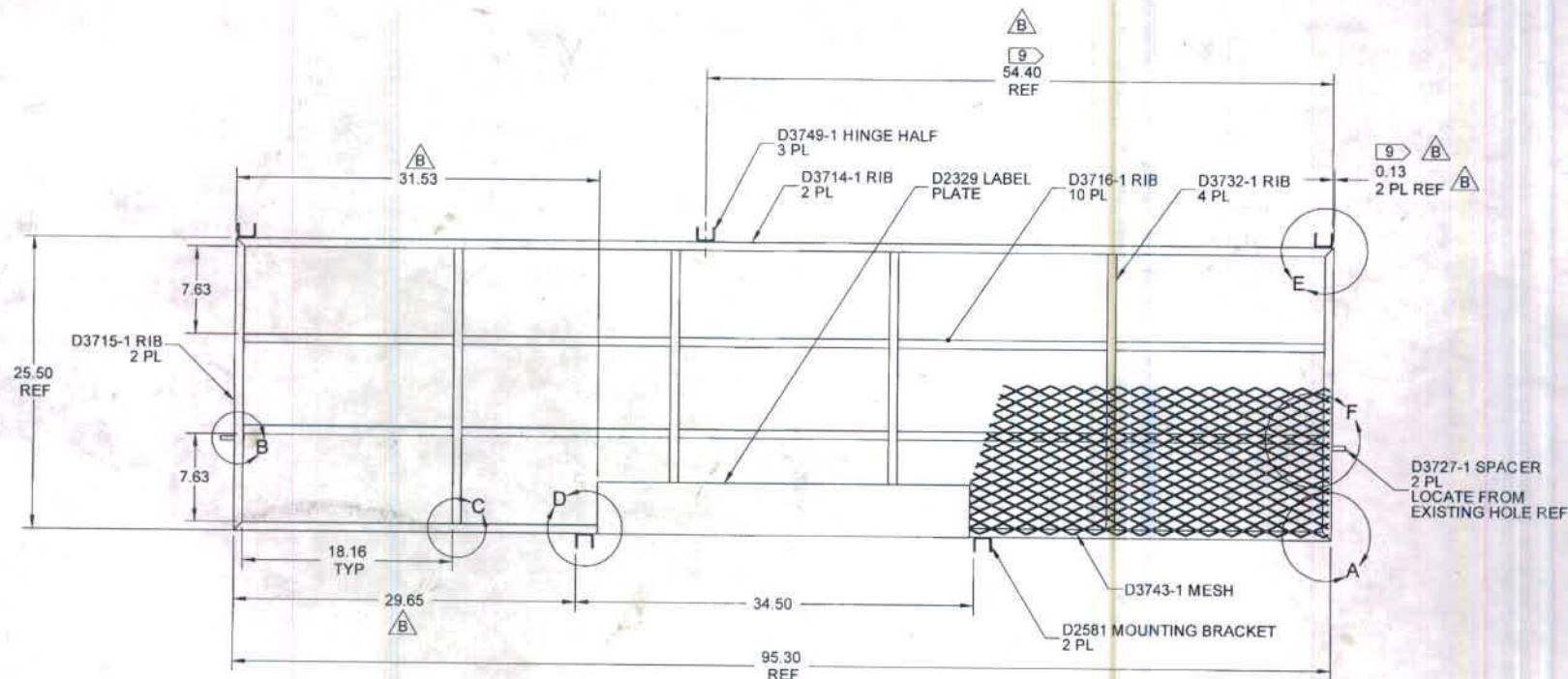


W/056578

108-037101D

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) WELDING: PER DART QSI 004
 - 9) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

B	SHEET 1 -042 WAS -041; ADDED CORRECT -041 ASSEMBLY. NOTE 9 ADDED. ZONE C2 LID ASSEMBLY WAS D3713-041. WEIGHT WAS 36 LBS. SHEET 2 ZONE B5 LID ASSEMBLY WAS D3713-041. ZONE D6 31.53 DIM WAS 31.64. ZONE D3 54.40 DIM NOW REF ZONE D2 0.13 REF DIM ADDED ZONE B6 29.65 DIM WAS 29.77. ZONE D3 & D2 FLAG NOTE 9 ADDED.		AJS	08.02.27
	A		AJS	08.02.01
REV.	NEW ISSUE		DESCRIPTION	BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	CE	DRAWING NO.		REV. B
MFG. APPR.	DS	D3713		SHEET 1 OF 3
APPROVED	AP	TITLE		SCALE
DE APPR.	AP	LID ASSEMBLY		NTS
DATE	08.02.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT BE NOT BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

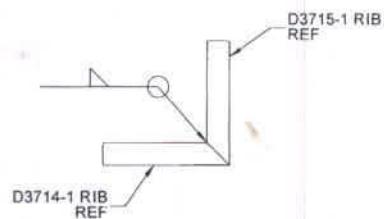


D3713-042 LID ASSEMBLY (SHOWN)
D3713-041 LID ASSEMBLY (OPPOSITE)
 (MESH SHOWN LOCALLY FOR CLARITY)

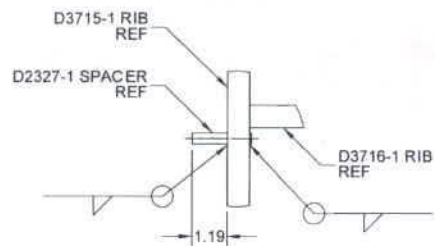
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08.02.27

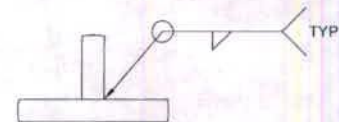
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3713	SHEET 2 OF 3
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	LID ASSEMBLY	NTS
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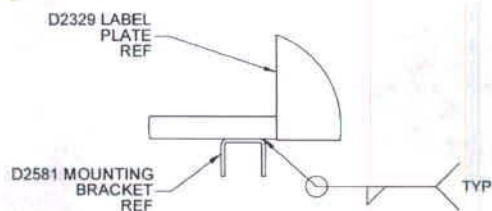
DETAIL A: TYP CORNER WELDS
SCALE 4X
(MESH NOT SHOWN FOR CLARITY)



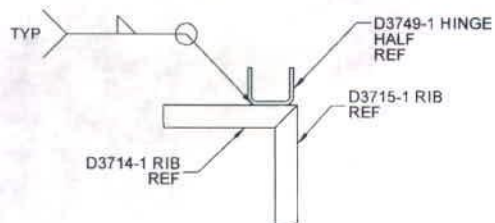
DETAIL B
TYP BOTH ENDS
SCALE 4X



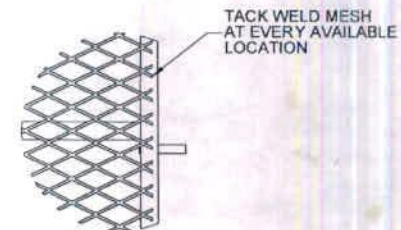
DETAIL C
TYP
SCALE 4X



DETAIL D
SCALE 4X



DETAIL E
SCALE 4X



DETAIL F
SCALE 5X

DESIGN	AJS	DART AEROSPACE LTD	
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CHECKED	ACE	DRAWING NO.	REV. B
MFG. APPR.	ACE	D3713	SHEET 3 OF 3
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